

Date: Friday, 10/13/2006 9:25:07 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EC 135 SKIDTUBE ASSEMBLY
Job Number : 28954	
Estimate Number : 12472	
P.O. Number : N/A	Part Number : D135751011
This Issue : 10/13/2006 S.O. No. : N/A	Drawing Number : D3507 REV <i>B 6/11/06 12.18</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 27809	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 11/10/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 06 10 13	
Comment : Est Rev: A 06-06-21 New Issue JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D135-751-011 CHG001 *CL*

2.0	D2962150	3.540 Outer Tube, Extrud
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150

Extrusion

B27774 DP 6-11-20

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes. *N/A*

4.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A". *N/A*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-06-12	250	1 D2965 cap required for Assy. Cap was powder coated black on original w/o.	QS1042	Sand the cap smooth with 320 grit. Pre-heat the D2965 cap, and powder coat white per QS1005.	07-07-06 [Signature]	CP 07-07-06	QS1042	07-06-12

NOTE: Date & initial all entries

Date: Monday, 12/18/2006 12:51:32 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28954

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

PTA

2-Cut Aft end at VC using DT8185

3-Deburr ends

4-Drill Aft & Fwd Cap holes using DT8678

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with 3/16cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using 3/16" drill.

7-Open Aft & Fwd Cap holes using .208" drill.

8-Drill pilot holes for wearplates using Dt8868

9-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3507.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Deburr holes.

6-11-20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/02/28 ①

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



07-02-28 ①



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

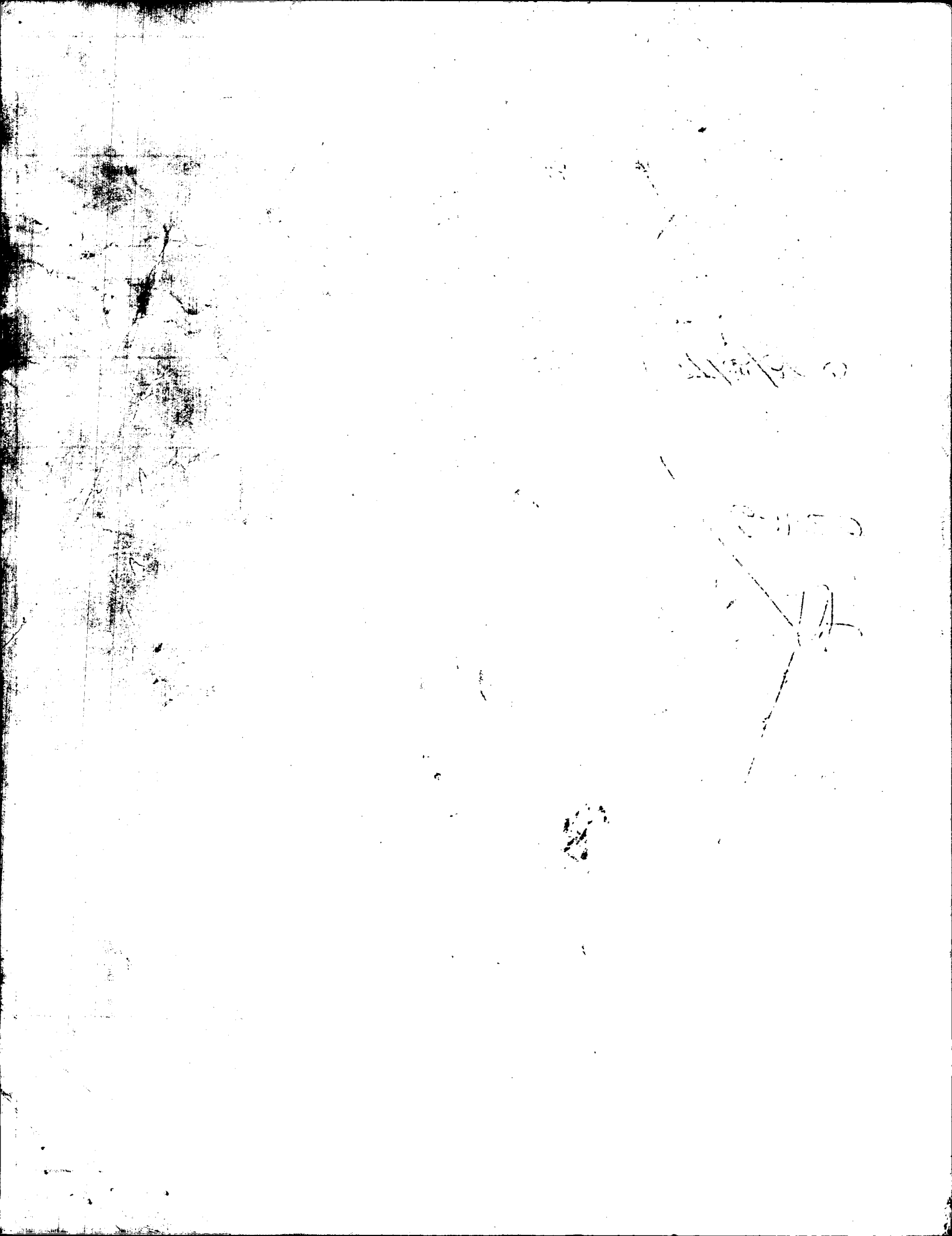
QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-02-28 ①



Date: Monday, 12/18/2006 12:51:32 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28954

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D35043	CROSSBOLT SPACER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSBOLT SPACER

Batch: B 28034 (1)

10.0	D35041	CROSSBOLT SPACER
------	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CROSSBOLT SPACER

Batch: B 31234 (2)

11.0	D35051	WEB
------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Batch: B 28962 Pm'07-03-01 (1)

12.0	D35061	DOUBLER
------	--------	---------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

DOUBLER

Batch: B 28963 Pm'07-03-28 (1)

13.0	D35063	DOUBLER
------	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

Batch: B 28964 Pm'07-03-28 (1)

14.0	MS20601AD4W3	Rivet
------	--------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch: B 8325 Pm'07-03-28 (1)

15.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507. and Detail "F" Pm'07-02-28 (1)

2-Counter Sink X-BOLT holes as per Dwg D3507 Pm'07-02-28 (1)

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Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description:

3-Debur and blow out chips from inside of tube. *Pm 07-02-280*

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: *M103497*

Exp Date: *07-10-01*

Pm 07-03-010

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: *10 M103317 BE 07-03-26*

6-Grind welds flush *BE 07-03-26*

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B *BE 07-03-26*

8-Debur Rivet holes. *BE 07-03-26*

Tools: E

16.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/280

17.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Pm 07-03-280

1-Rivet D3506-1/-3 as per Dwg D3507.

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/280

19.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 07/06/08 0

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/06/12

Date: Monday, 12/18/2006 12:51:32 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28954

Part Number: D135751011

Job Number:



Seq. #: Machine Or Operation: Description :

21.0 ALS71032130 Insert



* Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: m103495

22.0 ALS41032225 Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: m19393

23.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3507.

FL 07/06/12 ①

24.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

FL 06-12 ①

25.0 D2965 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B28959

PTO see first page

26.0 D29653 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B29993

27.0 D35081 WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B32884

FL 07/06/26 ①

Date: Monday, 12/18/2006 12:51:32 PM
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Job Number: 28954

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	D35083	WEARPLATE
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B32888

29.0	D35085	WEARPLATE
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B32886

30.0	D35087	WEARPLATE
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B32887

31.0	D35581	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B29998

32.0	D35583	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B29999

33.0	D35585	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B30000

34.0	D35587	GASKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B30001

FL 07/06/25 ①

Date: Monday, 12/18/2006 12:51:32 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28954

Part Number: D135751011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	D3492041	PLUG ASSEMBLY
------	----------	---------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PLUG ASSEMBLY ~~28954~~ 28922

Batch: 28922

36.0	D3492047	PLUG ASSEMBLY
------	----------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY 28961

Batch: 28961

37.0	AN660-B10L AN160C10L	Washer
------	----------------------	--------



Comment: Qty.: 35.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Batch: m104625

38.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 31.0000 Each(s)/Unit Total : 31.0000 Each(s)

BOLT

Batch: B m103641

39.0	AN3C5A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

m104118

FZ 07/06/25 ①

40.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: m104732

Exp Date: 07/10

3-Install Wearplates as per Dwg D3507 ,seal screws with sikaflex.

Note:Install (1) screw and (1) washer on Ground Wire insert on top of tube

Do not Install Scews where indicated on Dwg(Note #6)

A/R 241 Sika Flex Batch: m104732

Exp Date: 07/10

FZ 07/06/26 ①

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28954

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Install Plug assemblys as per Dwg D3507.

5- Wing Walk as per Dwg D3043 and QSI 005 4.4

FL 07/06/08 ①

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/07/07 x/

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D35121

WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WEARPLATE

Batch: 631199 ✓

44.0

MS27039-108

AN3C4A

Screw

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

~~Screw~~ BOLT

Batch: M104214 ✓

45.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

Batch: M103044 ✓

EP 07/07/08

46.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CS07/07/00①

2/7/9 SP ①

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-751011

Location:

PPP Rev:

PPPT

07/7/10 ①

SP

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EC 135 SKIDTUBE ASSEMBLY

Job Number: 28954

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Final

Job Completion



U 840711

28954A



DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED H	APPROVED H	DRAWING NO. D3507	REV. B SHEET 1 OF 2
DATE 06.11.01		TITLE EC 135 SKIDTUBE	SCALE NTS
A	06.04.21	NEW ISSUE	
B	06.11.01	ADD GASKET, CHANGE HARDWARE MAT'L	

RELEASED

06.12.12

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
4	AN3C5A	BOLT
35	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

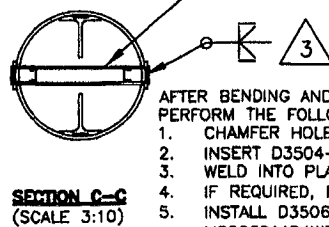
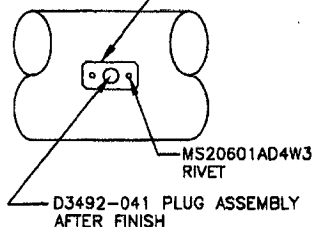
GENERAL NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) WELDING TO BE DONE PER DART QSI 004.
- 4) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 5) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 6) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- 7) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL)

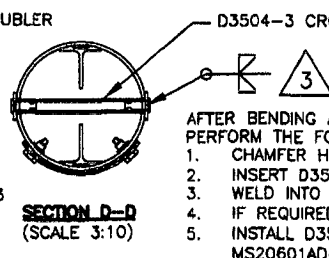
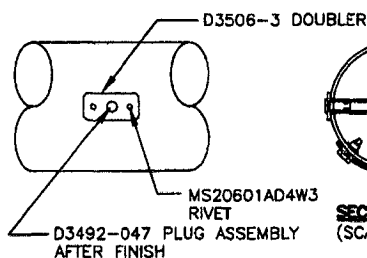
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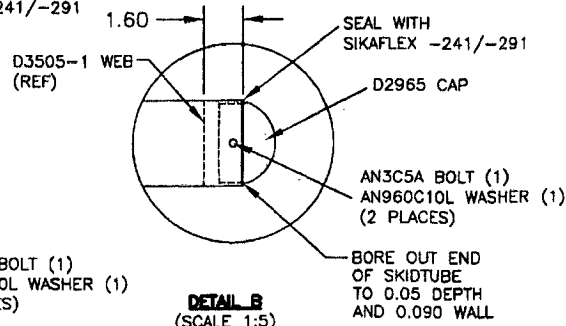
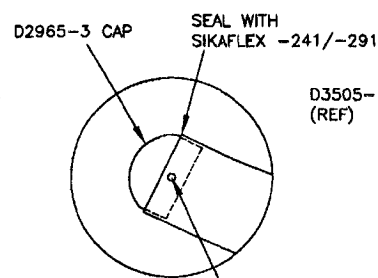
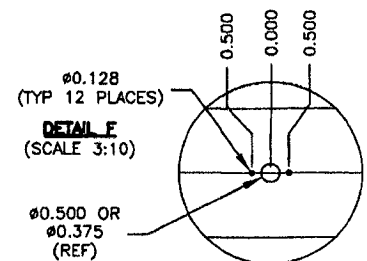
D3506-1 DOUBLER D3504-1 CROSS BOLT SPACER



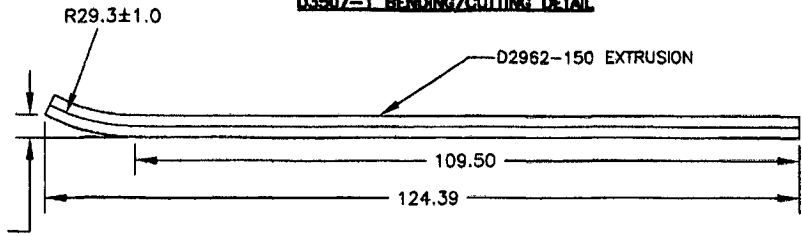
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR $\phi 0.500$ HOLES ONLY:
1. CHAMFER HOLE $0.030 \times 45^\circ$
 2. INSERT D3504-1 CROSS BOLT SPACER (2 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS $\phi 0.404$ ('Y' DRILL) THROUGH HOLE
 5. INSTALL D3506-1 DOUBLER (4 PLACES) USING MS20601AD4W3 RIVET (8 PLACES)
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY (4 PLACES)



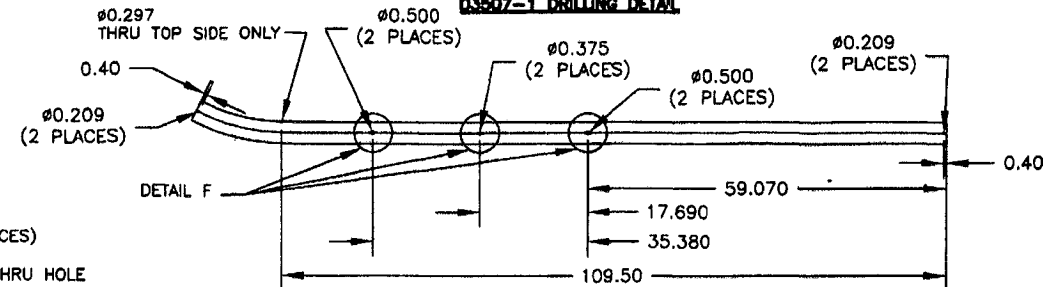
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:
1. CHAMFER HOLE $0.030 \times 45^\circ$
 2. INSERT D3504-3 CROSS BOLT SPACER (1 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS $\phi 0.277$ ('J' DRILL) DRILL THRU HOLE
 5. INSTALL D3506-3 DOUBLER (2 PLACES) USING MS20601AD4W3 RIVET (4 PLACES)
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY (2 PLACES)



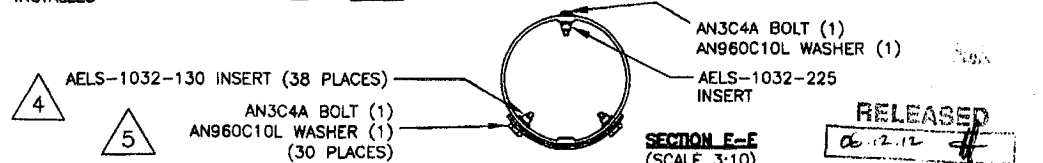
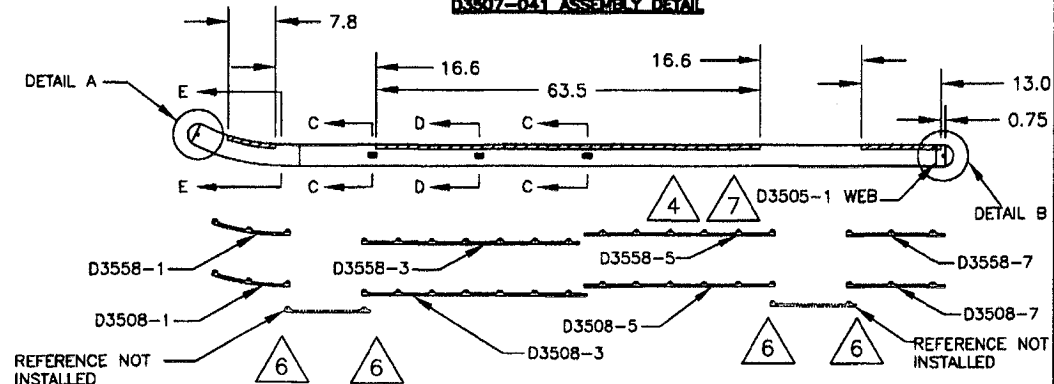
D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



D3507-041 ASSEMBLY DETAIL



RELEASED
06.12.12

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		CHECKED #	APPROVED #	DRAWING NO. D3507	REV. B
DATE 06.11.01		TITLE EC 135 SKIDTUBE ASSEMBLY		SCALE 1:20	
				SHEET 2 OF 2	

NO. 100

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Ray Bradley Elliott
Joint Welding Procedure Tig
Part number and Job number A135751011 / B 28956

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/26 Qualifier David Hux

Date: Friday, 10/13/2006 9:25:07 AM
 User: Kim Johnston

Process Sheet

45

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EC 135 SKIDTUBE ASSEMBLY
Job Number	: 28954		
Estimate Number	: 12472		
P.O. Number	:	Part Number	: D135751011
This Issue	: 10/13/2006 S.O. No. :	Drawing Number	: D3507 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 27809	Material	:
Written By	:	Due Date	: 11/10/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 06 10 13</u>		
Comment	: Est Rev:A 06-06-21 New Issue JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

06 10 18 JA

2.0	D2962150	3.540 Outer Tube, Extrud
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

REFERENCE ONLY

4.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".